

Date: Monday, 28/04/2008 8:13:27 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEAR PLATE
Job Number	: 38811		
Estimate Number	: 11231		
P.O. Number	:	Part Number	: D2348
This Issue	: 28/04/2008 S.O. No. :	Drawing Number	: D2348 REV B2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B2
Previous Run	: 31919	Material	:
Written By	:	Due Date	: 15/05/2008
Checked & Approved By	: <u>JLD 08.4.28</u>	Qty:	50 Um: Each
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0208 sf(s)/Unit Total: 1.0395 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick  
 (M6061T6S.063)  
 Batch: 105205 B 8-4-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2348  
 Dwg Rev: B2 B 8-4-30  
 Prog Rev: B2

2-Deburr if necessary

55  
08/05/05 55 Nu

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/05/05 55 cont

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

see step #2.2 08/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:27 AM  
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Drawing Name: WEAR PLATE

Job Number: 38811

Part Number: D2348

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5080515 (55) count*

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: \_\_\_\_\_

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

*Scrap*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT CERTS

10.0

FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert *10/634 (22x)*

*107897 (22x) 198+*

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

*208/05/20*

*(55) (24)*

12.0

QC5

INSPECT WORK TO CURRENT STEP

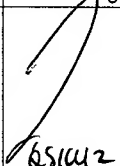
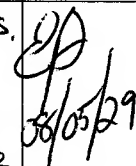
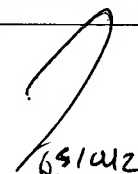
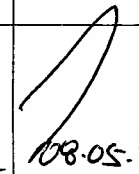


Comment: INSPECT WORK TO CURRENT STEP

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2348 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: DD Date: 08/05/29  
 QA: N/C Closed: AP Date: 28/05/30

NCR: 38811		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0805-22	11.0	Inserts were pressed into the parts, and the parts were not anodized. Steps 7.0, 8.0 & 9.0 were not completed. R.C. Employee continued with the parts, when previous steps of work was not completed, lack of attention to the process.	 651012	<ul style="list-style-type: none"><li>- Scrap &amp; destroy all parts.</li><li>- no replace.</li><li>- Ensure to double check w/o for completeness before starting a step, and continuing the process.</li></ul>	 08/05/29	815 08/05/29	 651012	 08-05-22

NOTE: Date & initial all entries

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Drawing Name: WEAR PLATE

Job Number: 38811

Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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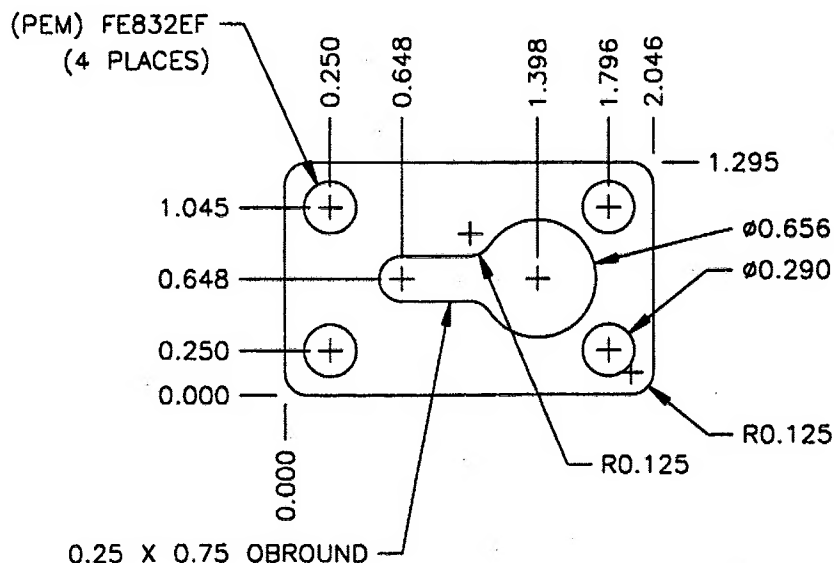
**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	[Signature]	D2348	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	02.02.21	CHANGE BACK TO 6061-T6	

RELEASED  
97/04/22 DS



- NOTES: 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)  
2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV CLASS 2  
3) INSTALL FE832EF INSERTS AFTER ANODIZING  
4) ALL DIMENSIONS ARE IN INCHES  
5) TOLERANCES ARE PER PART QSF 01B UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38811

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK  
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~